

Work Order ID 58658

Thursday, May 13, 2010 10:25:25 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 5/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date:

10-5-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *M115328*

0.00

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

lpl 10.05.20
SH 10/05/20

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

0.00

Memo

0.00

① PD 10.05.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5/10/05/21

Ⓟ

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

⇒ 10/05/21 1 Ⓟ

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 9:00 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:30 AM

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 10:00 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:30 AM

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 7 m. 10/05/21 (1X)

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

SPD
10-05-21

(1)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subst 1

(1)

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

WWS8778

SAD
10-05-21

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/25
MF
10-5-21

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Picklist Print

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Page 1

Work Order ID: 58658

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/13/2010


Required Date: 5/14/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC



IPP Rev:B

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-10A		Purchased	No			150	Each	88.0000	6			
												
Bolt												

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351		88						
				114330		88						
AN960JD8		Purchased	No			150	Each	0.0000	2			

												
Washer												
D2581		Manufactured	No			100	Each	36.0000	2			
												
Mounting Bracket												

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		36						
				46086		2						
				51745		2						
				57185		9						
				58301		23						

D2931		Manufactured	No			150	Each	864.0000	2			
												
Bumper												

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		864						
				46064		864						
D3913-1		Manufactured	No			100	Each	1.0000	1			

												
Rib												

				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		1						
				58124		1						

Dart Aerospace Ltd

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Required Date: 5/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
✓ D3913-15  Wide Handle Plate		Manufactured	No			100	Each	11.0000	1		<i>SM 10/05/17</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		11						
					58125	11						
✓ D3913-3  Rib		Manufactured	No			100	Each	2.0000	1		<i>① SM 10/05/17</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		2						
					58126	2						
✓ D3913-7  Rib		Manufactured	No			100	Each	2.0000	2		<i>① B58579 ② SM 10/05/17</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		2						
					58127	2						
✓ D3913-9  Hinge Rib		Manufactured	No			100	Each	2.0000	1		<i>B 58582 ① SM 10/05/17</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				WA		2						
					58128	2						

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 5/13/2010

Required Date: 5/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

✓ D3916-041 Rib Assembly		Manufactured	No			100	Each	2.0000	2			
-----------------------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--

B.58482 @ SJ 10/05/17

Location Loc Qty Loc Code

WA 2
58357 2

✓ D3916-5 Light Rib		Manufactured	No			100	Each	14.0000	3			
------------------------	--	--------------	----	--	--	-----	------	---------	---	--	--	--

SJ 10/05/17

Location Loc Qty Loc Code

WA 14
57023 2
57982 9
58360 3

✓ D4016-1 Hinge Half, Base		Manufactured	No			100	Each	9.0000	3			
-------------------------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--

SJ 10/05/17

Location Loc Qty Loc Code

WA 9
58132 9

✓ D4017-7 Rib		Manufactured	No			100	Each	4.0000	1			
------------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--

SJ 10/05/17

Location Loc Qty Loc Code

WA 4
57989 2
58133 2

Thursday, May 13, 2010 10:25:25 AM

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Page 3

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Required Date: 5/14/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
✓ D4017-9 Rib		Manufactured	No			100	Each	8.0000	2	 10/05/17		

Location	Loc Qty	Loc Code
WA	8	
58134	2	
58415	6	

D4020-1 Mesh (350 Basket Long, Base)		Manufactured	No			100	Each	0.0000	1	 SAD 10-05-19		
D4020-11 End Mesh, Basket		Manufactured	No			100	Each	14.0000	2	 10-05-17		

Location	Loc Qty	Loc Code
WA	14	
56990	1	
58136	13	

D4021-1 Handle Plate		Manufactured	No			100	Each	10.0000	3	 B58525 ① 10/05/17		
-----------------------------	--	--------------	----	--	--	-----	------	---------	---	-----------------------	--	--

Location	Loc Qty	Loc Code
ST109	5	
57086	5	
WA	5	
58139	5	

Thursday, May 13, 2010 10:25:25 AM

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Page 4

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chg qty's DD 10.04.12 verified by:EC





IPP Rev:B

Start Date: 5/13/2010

Required Date: 5/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4021-5  Blanking Plate		Manufactured	No			150	Each	13.0000	2			
				<u>Location</u>				<u>Loc Qty</u>				
				ST109				13				
					58140			13				
✓ D4034-041  Aft Upper Rib Assembly		Manufactured	No			100	Each	5.0000	1			
				<u>Location</u>				<u>Loc Qty</u>				
				WA				5				
					58141			5				
✓ D4034-043  Fwd Upper Rib Assembly		Manufactured	No			100	Each	5.0000	1			
				<u>Location</u>				<u>Loc Qty</u>				
				WA				5				
					58142			5				
MS20600-AD4W3  Cherry Rivets		Purchased	No			150	Each	1,825.000	2			
				<u>Location</u>				<u>Loc Qty</u>				
				ST321				1825				
					106375			3				
					107939			822				
					111636			1000				

SAD 10-05-21

2

10/05/17

①

10/05/17

①

SAD 10-05-21

2

Thursday, May 13, 2010 10:25:25 AM

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Dart Aerospace Ltd

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chg qty's DD 10.04.12 verified by:EC

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			150	Each	1,561.000	6			
Nut												

Location

Loc Qty

Loc Code

ST300

1561

113537

20

113644

541

114523

1000

NAS1149F0332P

Purchased

No

150

Each

887.0000

12



WASHER

Location

Loc Qty

Loc Code

ST275

887

18057

887

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

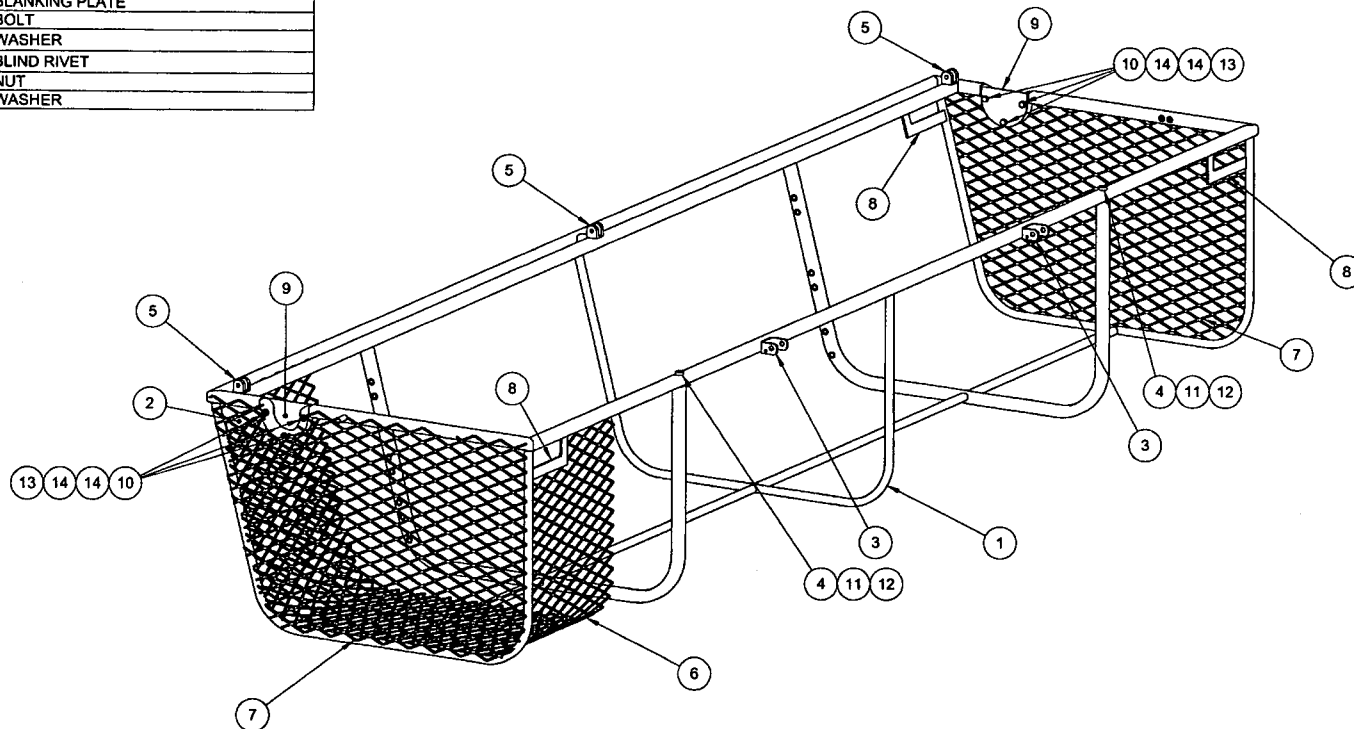
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JWH

A NEW ISSUE		JPH	10.03.16
REV.		DESCRIPTION	BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D8-2
D4020-1
MESH

D3913-101
TUBULAR ASSY

#58658

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL [8]

D2581
MOUNTING BRACKET
2 PL

D4016-1
HINGE HALF, BASE
3 PL

D4021-1
HANDLE PLATE
2 PL

D4021-1
HANDLE PLATE

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-02-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	XX	D3913	SHEET 2 OF 6
APPROVED	XX	TITLE	SCALE
DE APPR.	XX	LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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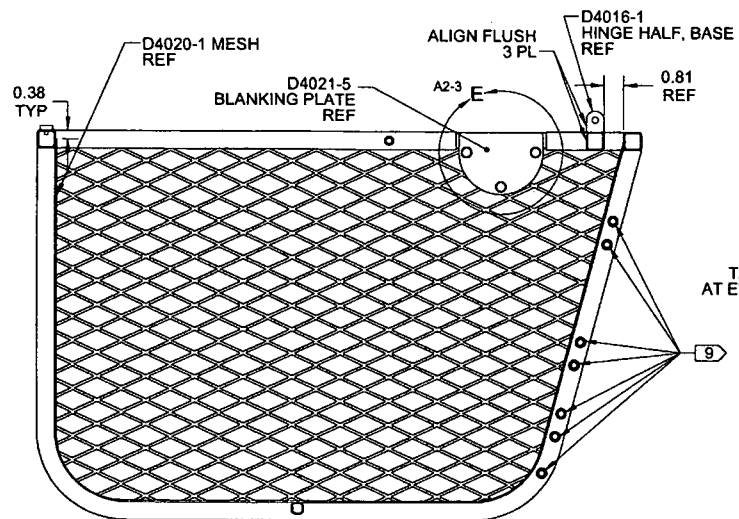
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

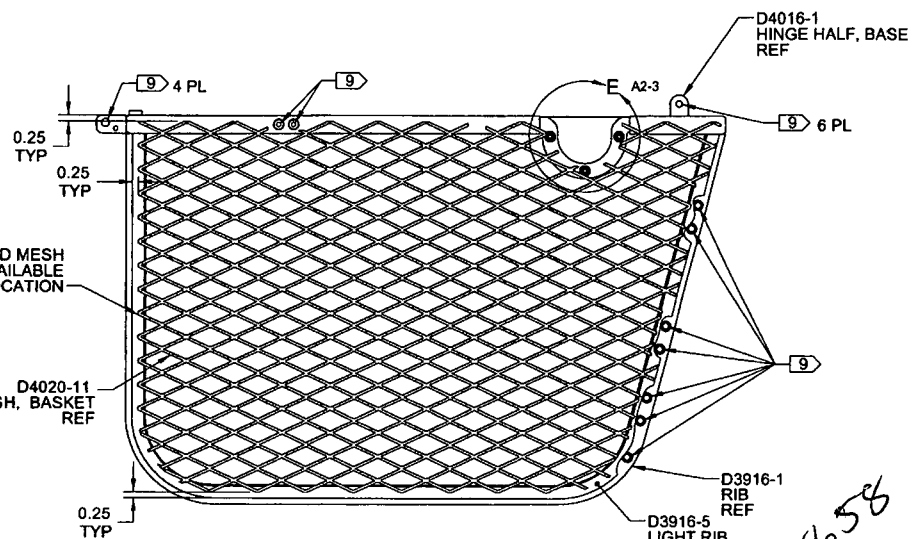
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

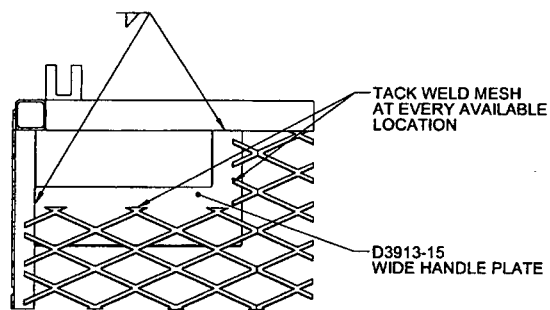
NOTE: Date & initial all entries



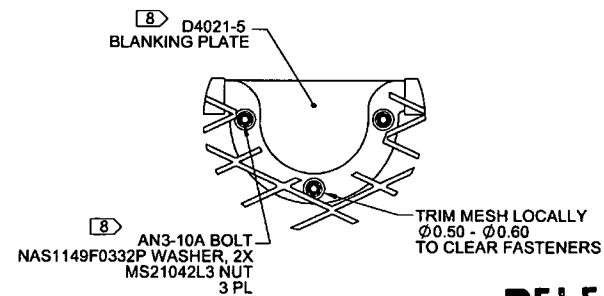
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JHH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

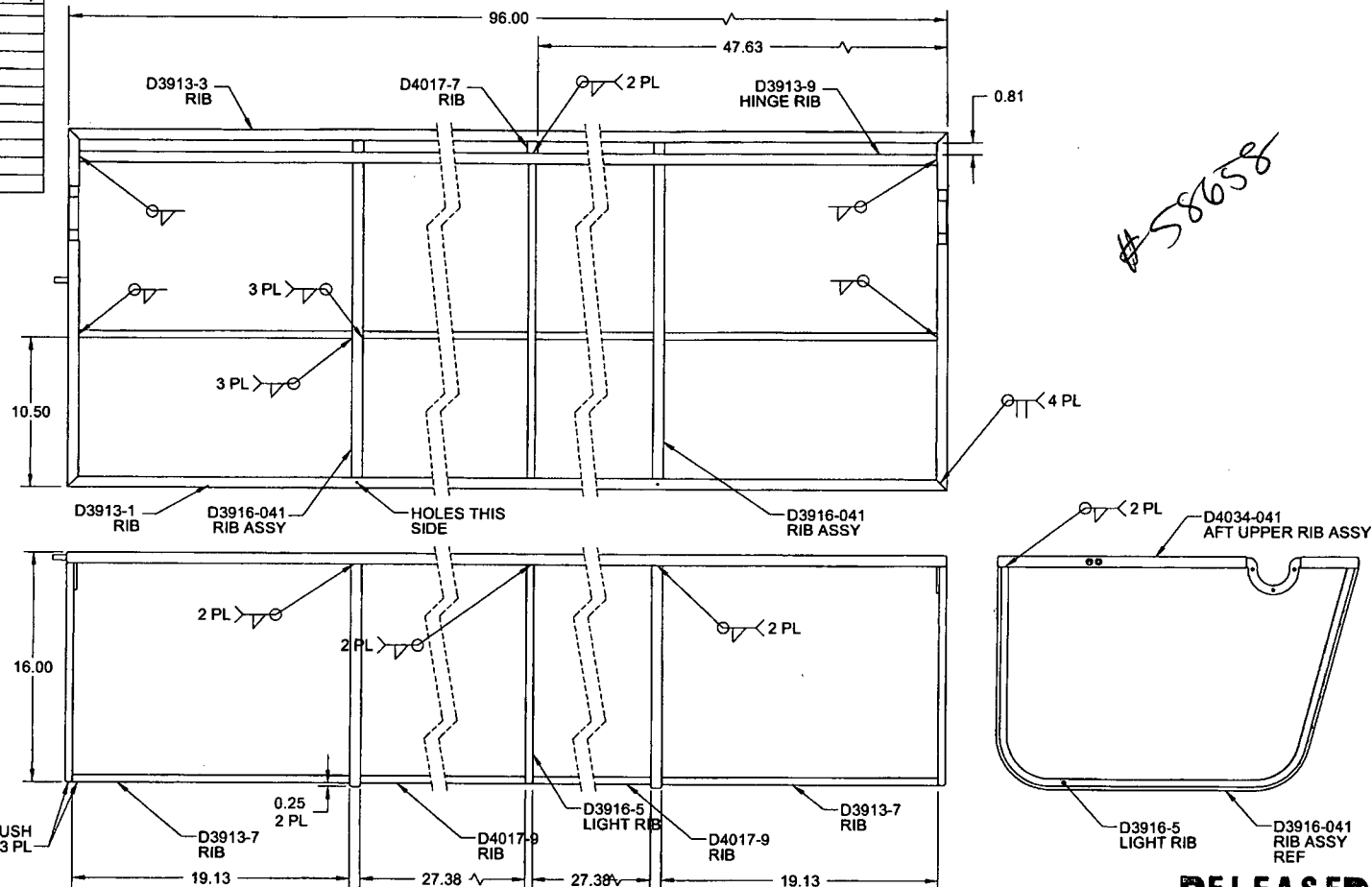
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.53 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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2010-03-22

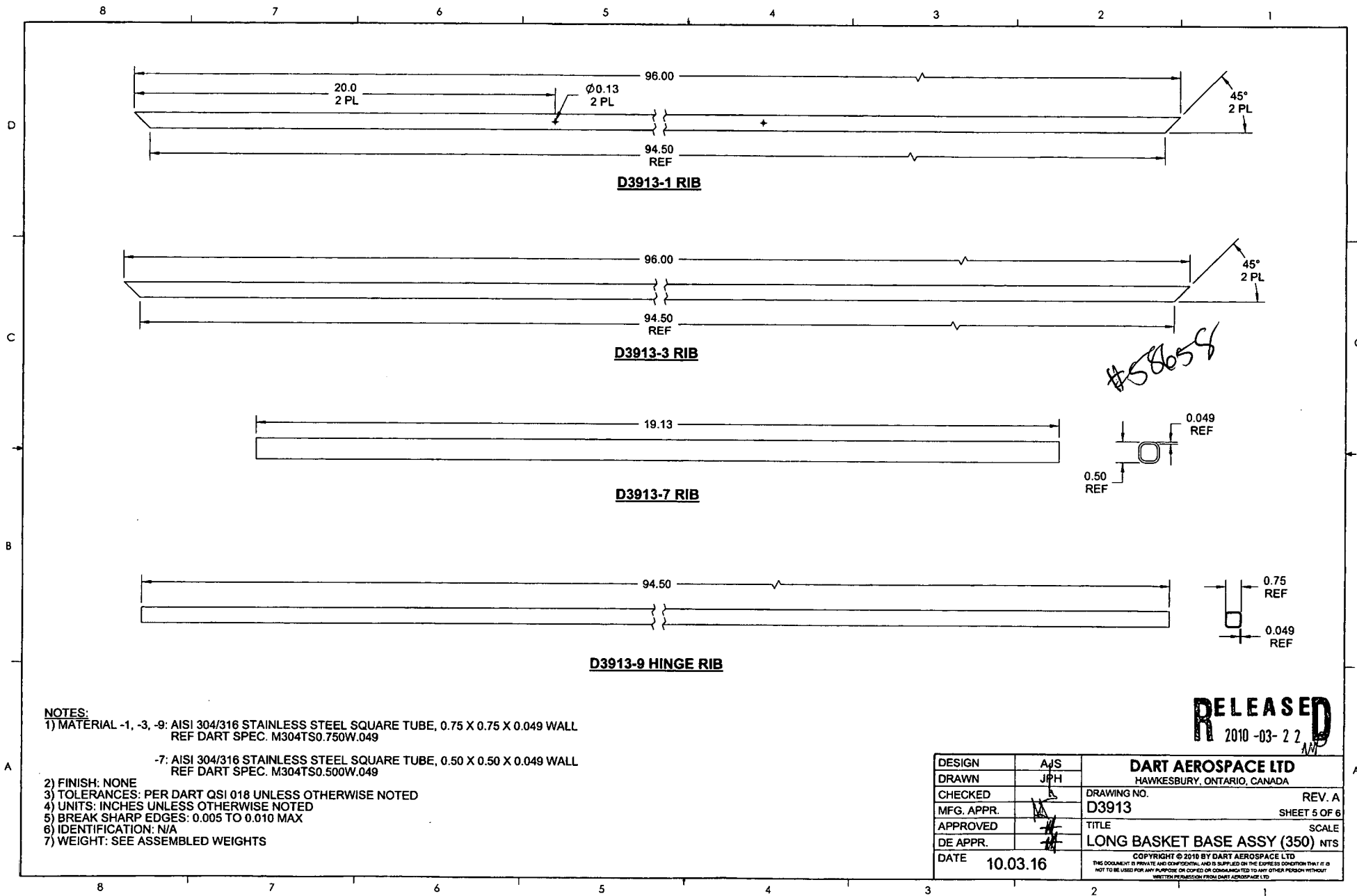
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



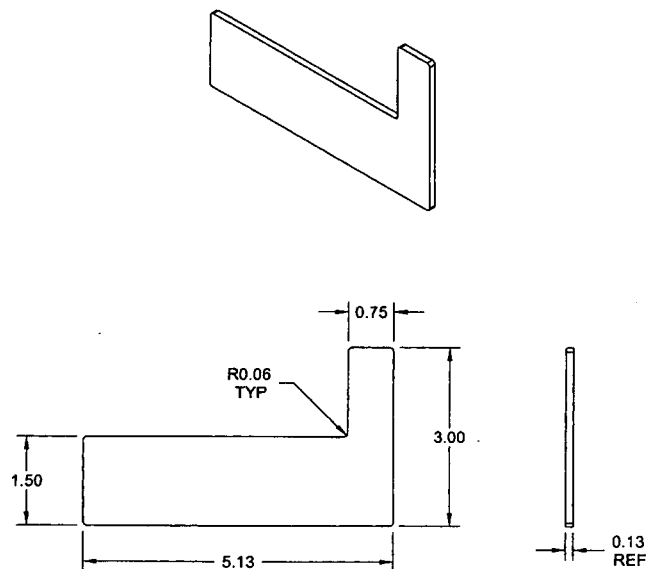
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries